Work Order ID 73307

Wednesday, August 31, 2011 10:47:21 AM

Item ID: D2022-101 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Spacer

Start Date: 9/1/2011 **Start Qty:** 50.00 **Cust Item ID:**

Required Date: 9/15/2011 **Req'd Qty:** 50.00 **Customer:**

Reference:

Approvals: **Process Plan:** MWF **Date:** 11-09-01 **Tooling:** **Date:** **Run Start**

QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
100		0.00							
Hardinge	**Memo**	0.00				50	Ø		
Hardinge CNC Lathe Small	Note:.257" dia drill 1-Turn as per folio FA206 & dwg FOLIO REV:_____ DWG REV:_____ 2-Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				50	Ø		
Quality Control									

W9/29

W9/29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 73307

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00	ark 11/09/29			50	~~0~~		
Quality Control									
130	Identify as per dwg & Stock Location: 504	0.00							
Packaging	Memo	0.00	county			11/9/29	(500)		
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00				11/10/3			
Quality Control									

MF 11-09-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Picklist Print

Wednesday, August 31, 2011 10:47:18 AM

Work Order ID: 73307

Parent Item: D2022-101

Parent Item Name: Spacer

Start Date: 9/1/2011 **Required Date:** 9/15/2011

Start Qty: 50.00 **Required Qty:** 50.00

Comments: IPP □D□02.03.07 □Now made in house□ NG□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750 6061-T6 Round Bar .750"		Purchased	No			100	f	32.5530	0.03	1.5		09/29	

Location	Loc Qty	Loc Code
MAT013	32.553	
112442	0.796	
116406	0.617	
117481	12.76	
118106	18.38	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	283417
Description: Spacer	**Part Number:**	D2022-101
Inspection Dwg: D2022 **Rev:** -		**Page 1 of 1**

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.226	+/-0.010	.227	✓		SG	
0.032 x 45°	+/-0.010	.032x45°	✓			
0.740	+/-0.010	.739	✓			
Ø0.257	+0.005/-0.000	Ø.259	✓			

Measured by:	[signature]	Audited by:	[signature]	Prototype Approval:	N/A
Date:	11/09/29	Date:	11/09/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.05	New Issue	KJ/JLM [signature]	[signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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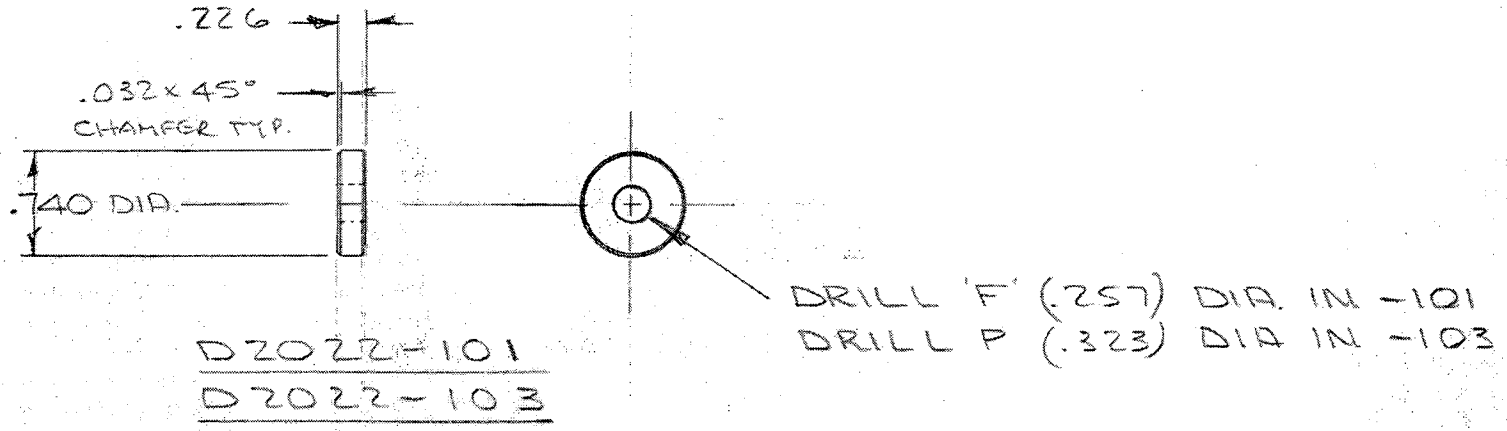
RELEASED
970119 BW



73307

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/8)

D2022

PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
D2022-103		SPACER 5/16	ALUM. 6061-T6	QQ-A-250/8
D2022-101		SPACER 1/4	ALUM 6061-T6	QQ-A-250/8

REVISION
DRAWN
APPROVED
DESCRIPTION OF CHANGE

THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.

REQUIREMENTS — UNLESS OTHERWISE SPECIFIED

GENERAL
1. DIMENSIONS ARE IN INCHES
2. SURFACE ROUGHNESS 125
3. REMOVE SHARP EDGES .015 MAX.
4. THREADS PER MIL - S - 7742
5. HOLES PER AND 10383

UNITS
1. TOLERANCES — .XX ± .030 .XXX ± .010
2. ANGLES ± 30'
3. PARALLELISM ± .0025
4. ECCENTRICITY .004 MAX.
5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005

REPORT ALL DISCREPANCIES — DO NOT SCALE

RIVET CODE SHALL BE PER NAS 523

BASIC CODE
D=DIMPLE
DIGIT NO OF SHEETS
C=COUNTERSINK

DIA. DASH NO.
M=HEAD MAR SIDE
P=HEAD FAR SIDE

LENGTH DASH NO.
W=SPOTWELD

BASIC CODES
B,M=NS204TORD
BB=NS204NAD

QTY. REQUIRED

APPROVAL

CONTRACT NO.

		DATE
DRAWN	BRADLEY	
DESIGN	BRADLEY	9/08/15
STRESS		
CHECKED		
CLIENT		

DART AERO ACCESSORIES INC

CLIENT

TITLE SPACERS

CODE

DWG. NO. D2022

REV.

SCALE 1:1 SHT 1 OF 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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